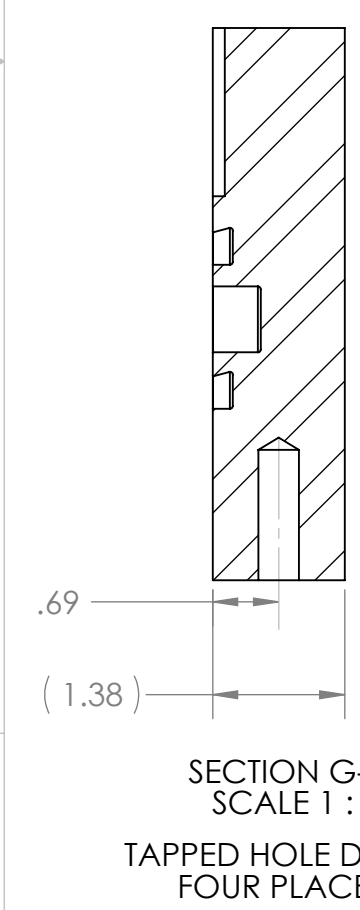
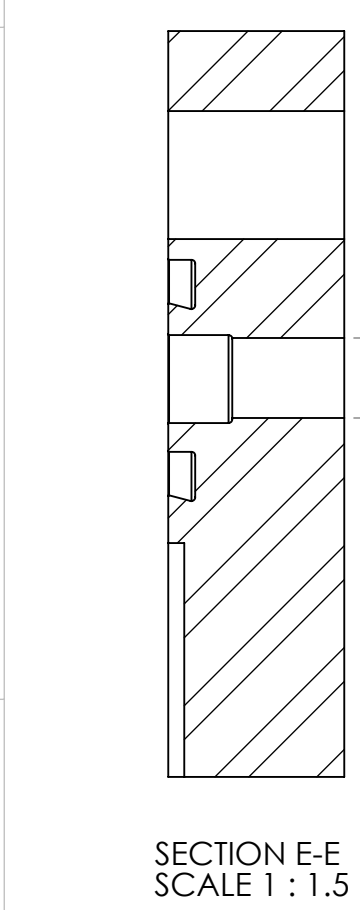
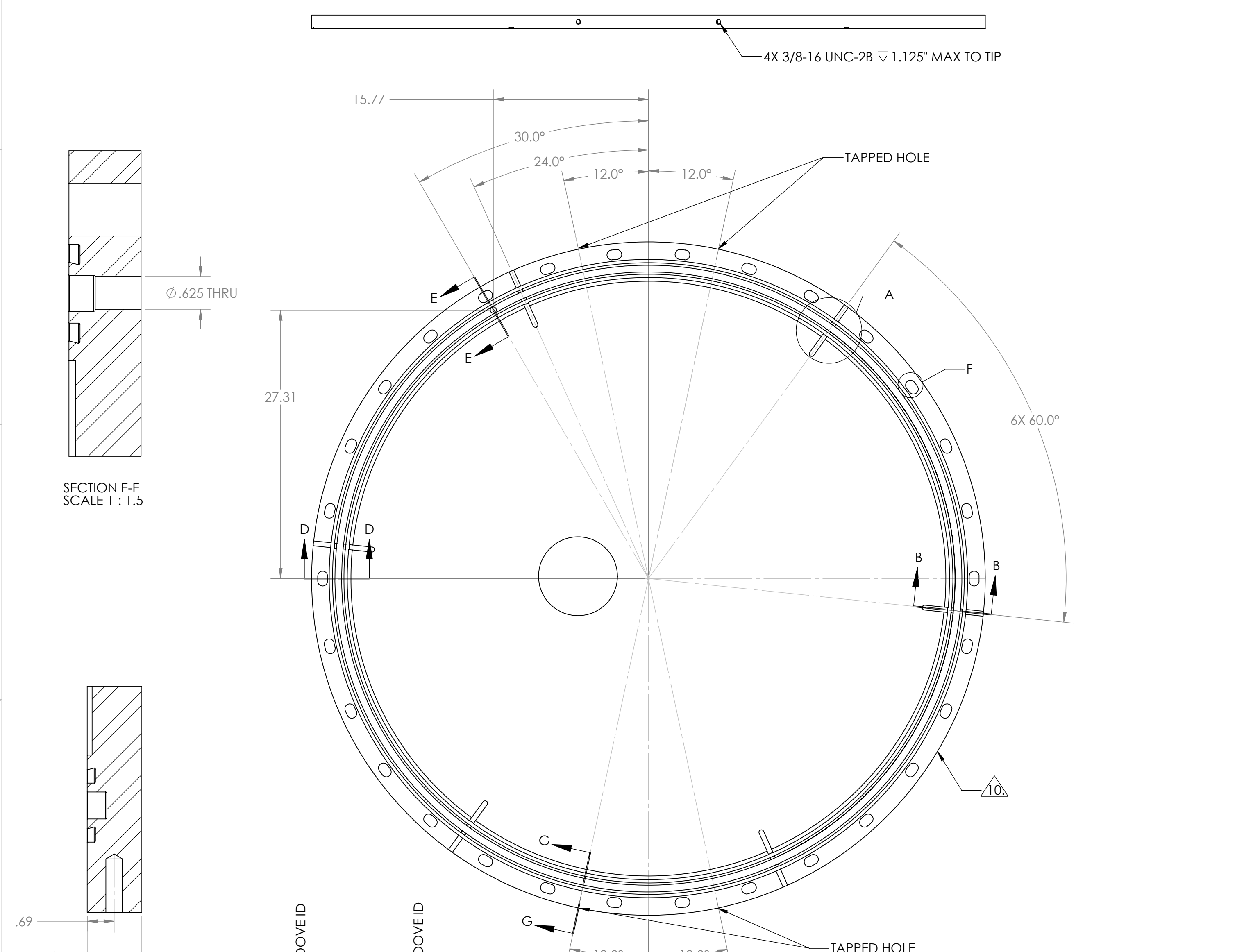
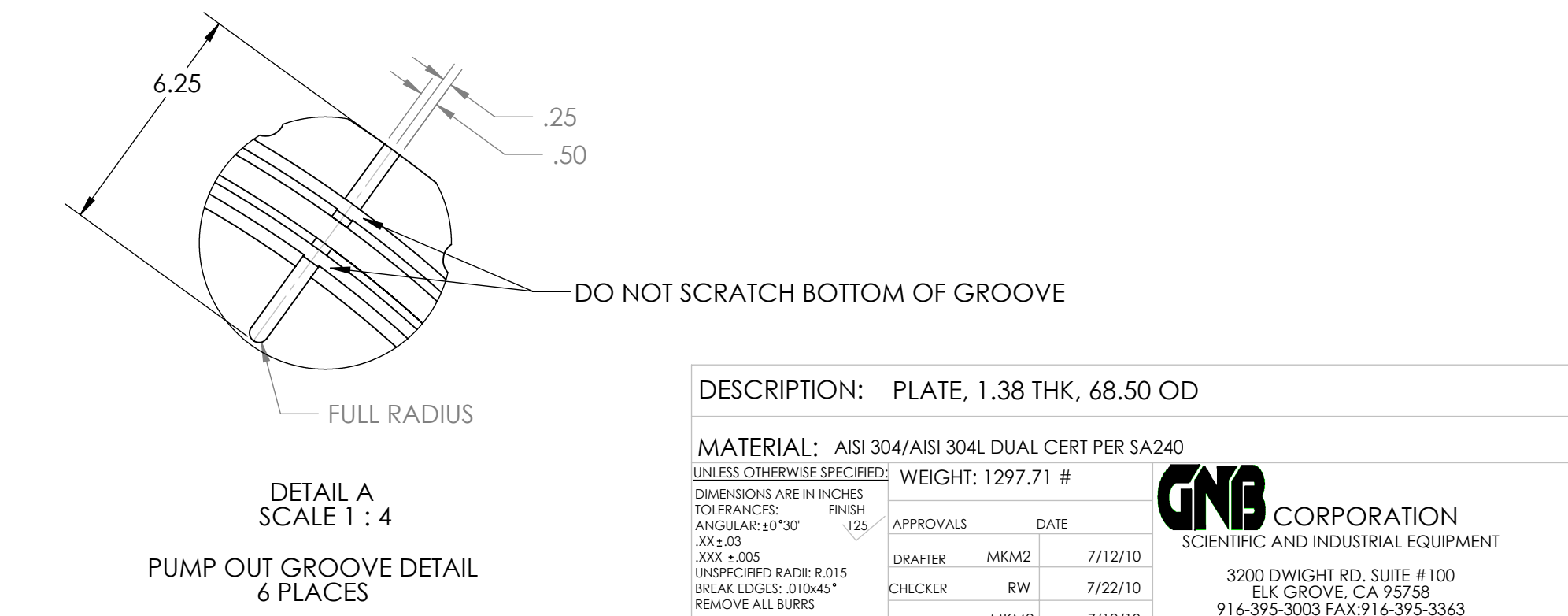
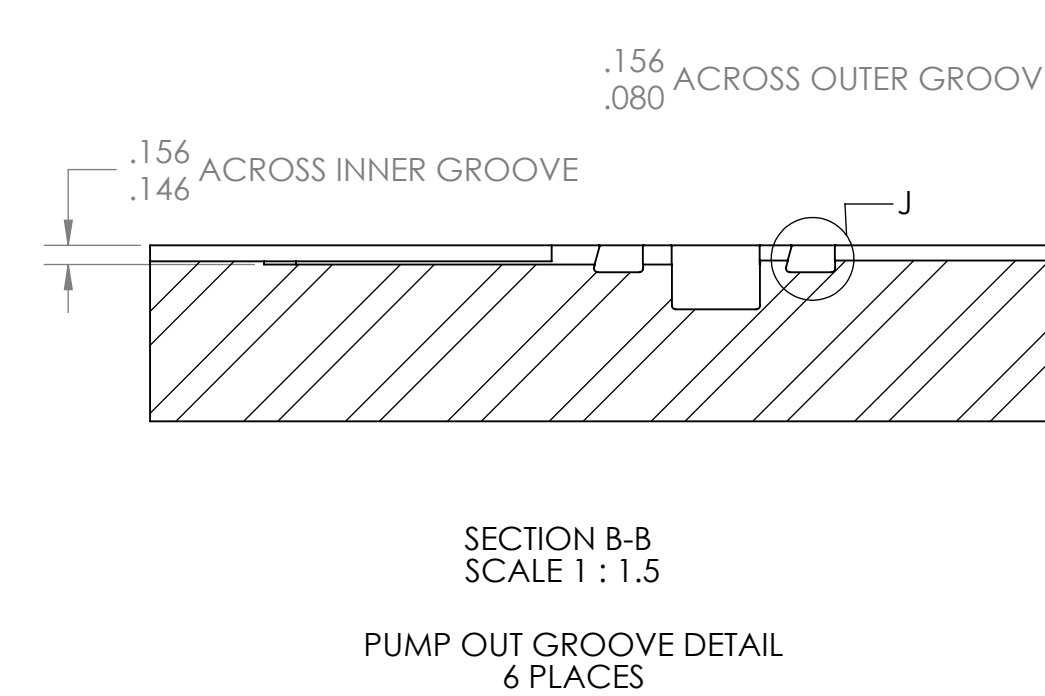
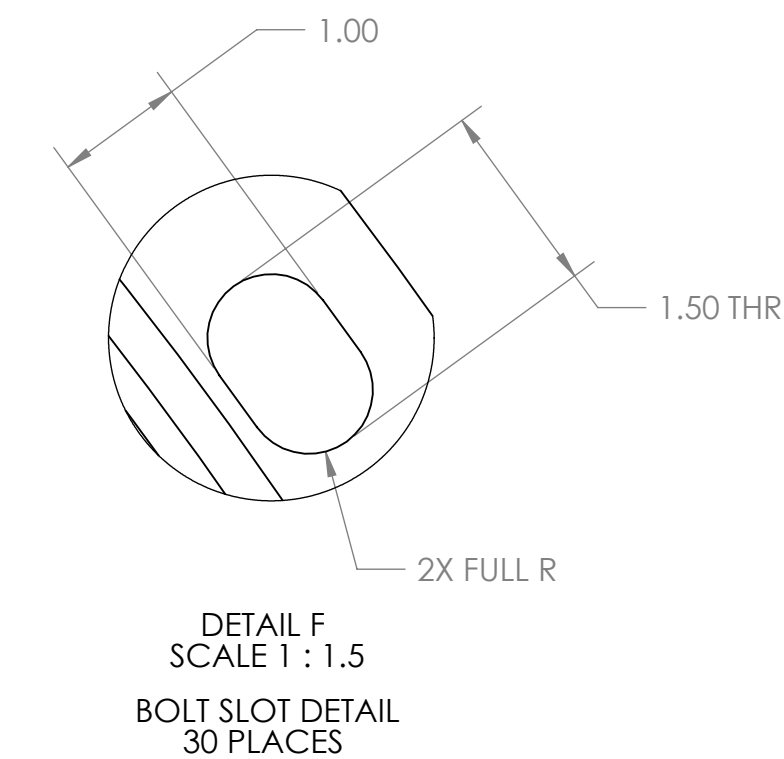
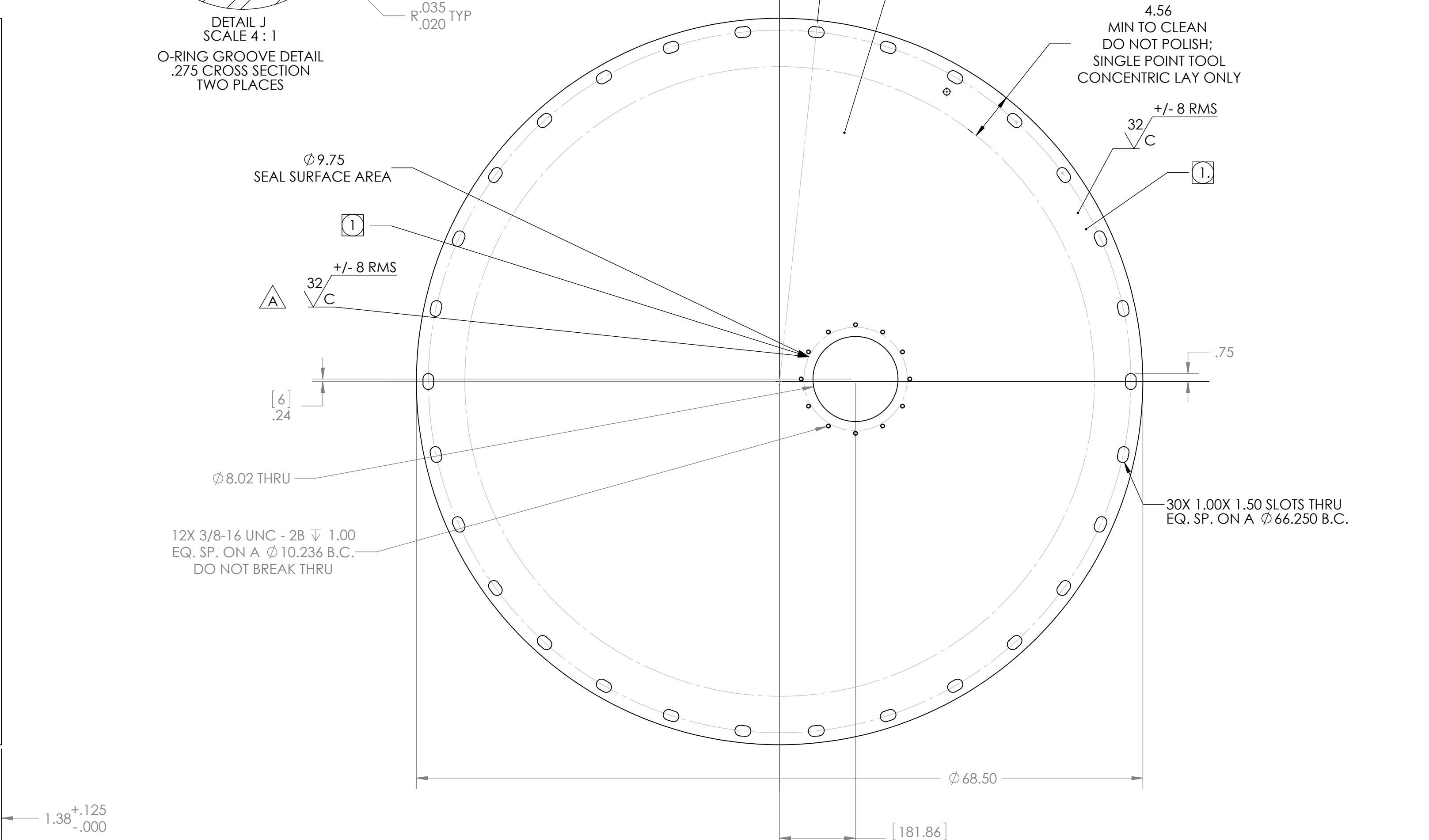
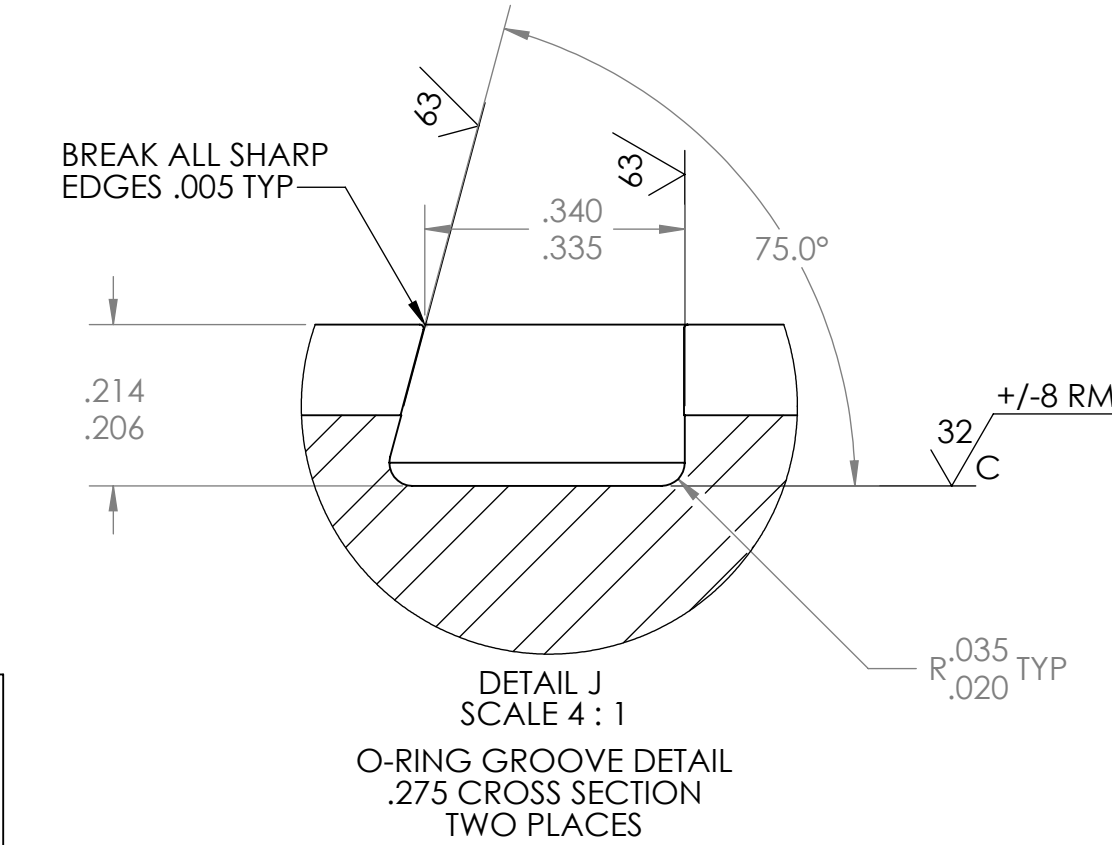


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| ZONE | REV. | REVISIONS                                |  | DATE      | APPROVED |
|------|------|--|--|-----------|----------|
|      |      | DESCRIPTION                              |  |           |          |
|      | A    | ADDED C CALLOUT ON FINISH, 7.16 WAS 7.17 |  | 1/11/2011 | MKM2     |



- NOTES:**
- VACUUM SEALING SURFACE
  - BOTH SURFACES OF PLATE WILL BE USED IN ULTRA HIGH VACUUM SERVICE.
  - ALL SEALING SURFACES SHALL MEET THE FOLLOWING REQUIREMENTS:
    - BASIC FINISH IS 32 RMS, CONCENTRIC LAY.
    - THE FOLLOWING ARE NOT ALLOWED: GRINDING, HONING, LAPPING, POLISHING, BUFFING, SANDING, BLASTING, OR ANY OTHER PROCESS THAT DISTURBS THE CONCENTRIC MACHINING LAY, IMBEDS MATERIAL INTO THE SURFACE, OR SMEARS THE SURFACE.
  - USE ONLY TUNGSTEN CARBIDE TOOLING TO MACHINE THIS PART.
  - O-RING GROOVES AND VENT GROOVE MUST BE MACHINED DURING THE SAME SETUP.
  - NO ABRASIVE STONES, CLOTHS, OR GRINDING WHEELS MAY BE USED.
  - NO OIL BASED OR HYDROCARBON BASED CUTTING FLUIDS MAY BE USED. SEE QP1730-10 SECTION 4 FOR APPROVE FLUIDS. NO HYDROCARBONS ALLOWED IN THE COOLANT. COOLANT LIMITS AS FOLLOWS
    - WATER LEACHABLE CHLORIDES: 100PPM
    - TOTAL HALOGENS (INCLUDING CHLORIDES): 1000PPM
    - TOTAL SULFUR: 1000PPM
  - DO NOT ALLOW PART TO BE CONTAMINATED BY CARBON STEEL OR IRON CONTACT.
  - MACHINING TO BE IN LINE WITH LIGO SPECIFICATION E0900406, LATEST REVISION.
  - SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO DYES OR INKS) PART NUMBER 1003343\_V2 ON NOTED SURFACE OF THE PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER (001). USE MINIMUM .12" HIGH CHARACTERS. A VIBRATORY TOOL MAY BE USED.
  - LEAK CHECK SEPTUM PLATE 10^-9 ATM-CC/SEC TO QP1750-A7.
  - PACKAGE, HANDLE, AND SHIP IN ACCORDANCE WITH BOTH QP1730-10 AND QP1750-R6.



|  |                     |
|--|---------------------|
| DESCRIPTION: PLATE, 1.38 THK, 68.50 OD               |                     |
| MATERIAL: AISI 304/AISI 304L DUAL CERT PER SA240     | WEIGHT: 1297.71 #   |
| UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES |                     |
| TOLERANCES:  | FINISH              |
| ANGULAR: ±10°/30°                                    | 125                 |
| XXX ±.005  |                     |
| UNSPECIFIED RADII: R.015                             |                     |
| BREAK EDGES: 0.10x45°                                |                     |
| REMOVE ALL BURRS                                     |                     |
| WITHIN .03   |                     |
| THIRD ANGLE PROJECTION                               |                     |
| APPROVALS  |                     |
| DRAWER: MKM2   | DATE: 7/12/10       |
| CHECKER: RW  | DATE: 7/22/10       |
| ENGINEER: MKM2                                       | DATE: 7/12/10       |
| TITLE: PLATE, SEPTUM, H1, L1 PRC                     |                     |
| DO NOT SCALE DRAWING                                 | DWG. NO. 114425-01S |
| SCALE: 1:8   | SHEET 1 OF 1        |
|  | REV. A              |